



Dart Hawkesbury
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Tel (613) 632-5200

D4634-141
Job Sheet 167074-L



Part No: D4634-141 Job Qty: 1 ea
Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs Status: Scheduled Priority: Medium
Job Created: 10/23/17 Job Tracking No:
Due Date: 11/24/17 Created By: Mario Poulin
Type: SOLD Description:
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	DML 18-1-23
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	DML 18-1-23
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	DML 18-1-23
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	38
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	DML 18-1-31
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	38

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-1 F164288	1	3	0	0
	D4636-55 004455	1	43	0	0
	D4647-5 9683352	1	2	0	0
	D4664-55 011418	6	39	0	0
	D4712-1 5008996	1	4	0	0
	D4732-155 008991	1	2	0	0
	D4732-19 5008993	1	1	0	0
	D5021-1 5017834 5019540	1	2	0	0
	MPNY-750S-9-C F-M1304237	1	570	0	0
	MS20426AD3-4 F-M134294	4	5,055	0	0
	MS20426AD4-6 F-M1386212	2	2,797	0	0
	MS21059L086 5019317	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: _____

DISPOSITION

Rework	☐
Sp	☐
is	☐
id	☐

Skid-tube	☐
Machining	☐
Thermof	☐
La	☐
Q1	☐

AGAINST DEPARTMENT/PROCESS

Cross tube	☐
Small Fahl	☐

Water Jet	☐
Prod. Eng. Coord.	☐

Engineering	☐
Quality	☐
Other	☐

Date

(042) Approval

Completed By

id / Supervisor
al Verification

A Coordinator
approval

oned Wrong
je Dimensions
Under tolerance
ncorrect
ost/Missing
loved
ng
ad
ng Sequence

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Job No 167074-L

DART
AEROSPACE
S034829



Fwd, Center Ceiling Replacement Panel Assembly

PART NO: D4634-141

Original Serial #: S034829

Revision:

Operation: Start up Operation 01/24/18

Change No: Job No: 167074-L

Misidentified ☐ Past Due ☐ OTHER: ☐